

Work Order ID 85671

85671

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June-13-12 1:51:46 PM

Item ID: D412-742-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Skidtube Installation
 Start Date: 6/13/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/14/12 Req'd Qty: 1.00 ***1*** Customer: CU-DAR001
 Reference: RMA RA111377 - RETURN

Approvals: Process Plan: [Signature] Date: Tooling: Date: Run Start ***NR1***
 QC: [Signature] Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-742	E								

100 0.00

100

QC

Quality Control

Memo

INSPECT RA111377
1 X D412-742-013 B83154

0.00

8/24/13

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-6200	
P/N	D412-742-013	CHG	CHG007
DESC.	Float Skidtube	STC	SR01583SE
LOT	B83154	STC	SH05-37
MODEL	205/210/212/412/AB412	STC	
PATENTS US #5735464 CA #2222184 EUROPEAN No #0828655		MADE IN CANADA 02729-2	

110

110

HandFinish

Hand Finishing

Memo

REMOVE FWD AND AFT WEARPLATES
HAVE QC TEST FIT SADDLES

RE-INSTALL ORIGINAL FWD AND AFT WEARPLATES AFTER TEST FIT
OF SADDLES

REMOVE AFT CAP AND FWD CAP-SCRAP/DESTROY

REPLACE

NEW AFT CAP 1 X D2646 B *81974*

NEW FWD CAP 1 X D3401-041 B *83432*

TOUCH UP ANY AREAS A/R

0.00

1x 1 1/2 1/4 1/8 1/16 1/32 1/64 1/128 1/256 1/512 1/1024 1/2048 1/4096 1/8192 1/16384 1/32768 1/65536 1/131072 1/262144 1/524288 1/1048576 1/2097152 1/4194304 1/8388608 1/16777216 1/33554432 1/67108864 1/134217728 1/268435456 1/536870912 1/1073741824 1/2147483648 1/4294967296 1/8589934592 1/17179869184 1/34359738368 1/68719476736 1/137438953472 1/274877906944 1/549755813888 1/1099511627776 1/2199023255552 1/4398046511104 1/8796093022208 1/17592186044416 1/35184372088832 1/70368744177664 1/140737488355328 1/281474976710656 1/562949953421312 1/1125899906842624 1/2251799813685248 1/4503599627370496 1/9007199254740992 1/18014398509481984 1/36028797018963968 1/72057594037927936 1/144115188075855872 1/288230376151711744 1/576460752303423488 1/1152921504606846976 1/2305843009213693952 1/4611686018427387904 1/9223372036854775808 1/18446744073709551616 1/36893488147419103232 1/73786976294838206464 1/147573952589676412928 1/295147905179352825856 1/590295810358705651712 1/1180591620717411303424 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Work Order ID 85671



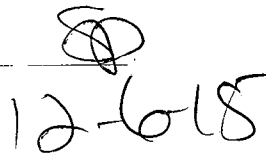

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Item ID: D412-742-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Skidtube Installation
 Start Date: 6/13/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/14/12 Req'd Qty: 1.00 ***1*** Customer: CU-DAR001
 Reference: RMA RA111377

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Packaging Packaging	Memo ENSURE ORIGINAL KIT IS IN BOX	0.00 0.00							
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

Work Order ID 85671

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Item ID: D412-742-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Skidtube Installation
 Start Date: 6/13/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/14/12 Req'd Qty: 1.00 ***1*** Customer: CU-DAR001
 Reference: RMA RA111377

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Packaging		0.00							
Packaging	<i>Albert</i> Memo REPACKAGE USING NEW B/N NEW LABELS AND PAPERWORK REQ'D <i>SHIP</i>								<i>01/26/10</i>
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									<i>MLJ 12/06/15</i> <i>mk</i> <i>12-06-15</i>

Picklist Print

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Work Order ID: 85669

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/13/12

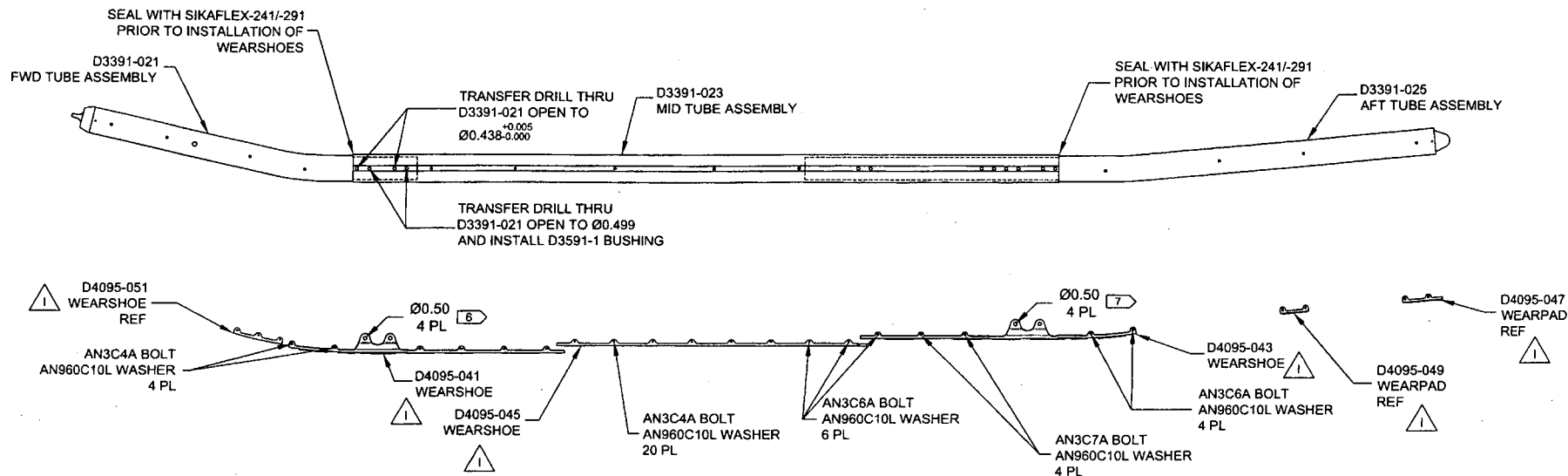
Required Date: 6/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DSI9441 DD verified by: EC IPP Rev: F add AN4C7A DD
 10.01.13 verified by: EC IPP Rev: G 11.11.01 as per DSI9517 REV.B DD verified
 by: EC IPP rev: H 12.01.12 PER IIN REV.E DD VERF: IPP Rev: I add AN4C47A
 DD 12.03.14 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2646 Aft Cap		Manufactured	No				Each	56.0000		1		12/06/14	V-270
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		56							
				62678		5							
				68280		5							
				70945		1							
				71070		2							
				73294		1							
				73825		2							
				78018		1							
				79562		5							
				81974		34							
D3401-041 Tow Cap Assembly		Manufactured	No				Each	19.0000		1		12/06/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		19							
				78990		1							
				82302		8							
				83432		10							
D412-742-013 Float Skidtube Installation		Manufactured	No				Each	0.0000				083154 (x1) 12/06/14	



D3391-043 ASSEMBLY



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

**Instructions for RA 111377 D412-742-013 B83154 CHG
007**

- Box was damaged see pictures
- Kit complete
- Aft cap is scrap **see pic**
- Fwd. cap is scrap **see pic**
 - Aft angle = **6.58***
 - Fwd. angle = **13.0***
 - Remove fwd. and aft wear plates and test fit saddles
- Needs new BATCH #
- Needs new Paper Work & Labels

Time Estimate = 5 HOUR ONLY
Departments Required: 4-FINISHING 1-STORES
Pictures Attached = YES

**Instructions for RA 111377 D412-742-013 B81083
CHG007**

- Box was damaged see pictures
- Kit complete
- Aft cap is scrap **see pic**
- Fwd. cap is scrap **see pic**
 - Aft angle = **6.0***
 - Fwd. angle = **12.23***
 - Remove fwd. and aft wear plates and test fit saddles
- Needs new BATCH #
- Needs new Paper Work & Labels

Time Estimate = 5 HOUR ONLY (stores)
Departments Required: 4-FINISHING 1-STORES
Pictures Attached = YES